



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D4855-1

Job Sheet 191499



Part No: D4855-1

Job Qty: 12 pcs

Part Name: Antenna Bracket



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/4/19

Job Tracking No:

Due Date: 3/22/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV A SHEET 1 IPP REV: A NEW ISSUE JFS 13/06/26 VERIFY BY: DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	12 pcs	3/22/19		0.00	0.34	Bandsaw - 1	DAS 52 9-89	19/03/07
110	HAAS 4 Axis - B4B	12 pcs	3/22/19		0.29	10.53	HAAS - 1 - B4B		19/04/07
							HAAS - 2 - B4B	DAS	
							HAAS - 3 - B4B	52	
							HAAS - 4 - B4B	9-89	
130	QC 8	12 pcs	3/22/19		0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		19/05/07
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
140	Handfinish - 1-1 Chemical-B4B	12 pcs	3/22/19		0.00	0.48	Handfinish - 1 - 1 - B4B		
							Handfinish - 1 - 2 - B4B		



Container No: S178462



Part: D4855-1

Job No: 191499

Serial No/Batch: S178462

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
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Date: 05/07/19

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				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	DR 19/05/10
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
150	QC 7	12 pcs	3/22/19	0.00 0.00	QC 7 - 10
					QC 7 - 13
					QC 7 - 14
					QC 7 - 15
					QC 7 - 17
					QC 7 - 18
					QC 7 - 19
					QC 7 - 2
					QC 7 - 28
					QC 7 - 3
					QC 7 - 30
					QC 7 - 34
					QC 7 - 36
					QC 7 - 37
					QC 7 - 41
					QC 7 - 47
					QC 7 - 48
					QC 7 - 51
					QC 7 - 58
					QC 7 - 59
					QC 7 - 6
					QC 7 - 60
					QC 7 - 9

BEB 19-05-10

DAS 59 9-89

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				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
190 QC 21 - SA	12 pcs	3/22/19	0.00 0.00	QC 21 - SA - 21	DAC
				QC 21 - SA - 70	21 MAY 17 2019
				QC 21 - SA - 53	9-55

Part Op 100 - (Bandsaw) CUT BLANK AT 3.000"
 Descriptions: 110 - (HAAS CNC Vertical Machine) 1-Machine per folio FB200
 130 - (QC8- Inspect parts - second check)
 140 - (Chemical Conversion Coat per QSI005 4.1)
 150 - (QC7-Inspect Chemical Conversion Coat)
 160 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: _____
 170 - (QC3- Inspect Part Finish)
 180 - (Identify as per dwg & Stock Location: _____)
 190 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B4.500X4.500	6061-T6 Aluminumbar 4.500" X 4.500" (CUT IN SECTION 6ft)	3 ft (.25 ea)	100-Bandsaw - 1	① 5121736
				② 5168973

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M6061T6B4.500X4.500	3	11	0

MAT
used
1.521'
1.521'

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Antenna Bracket	0.875Inches ± 0.010	0.885 0.865	0.875	
2	Antenna Bracket	0.201Inches $+ 0.005$ $- 0.001$	0.206 0.200	0.201	Diameter
3	Antenna Bracket	0.970Inches ± 0.030	1.000 0.940	0.970	
4	Antenna Bracket	0.970Inches ± 0.030	1.000 0.940	0.970	
5	Antenna Bracket	1.880Inches ± 0.030	1.910 1.850	1.880	
6	Antenna Bracket	3.750Inches ± 0.030	3.780 3.720	3.752	
7	Antenna Bracket	0.250Inches ± 0.030	0.280 0.220	0.250	Radius
8	Antenna Bracket	0.257Inches $+ 0.005$ $- 0.000$	0.262 0.257	0.257	Diameter
9	Antenna Bracket	2.130Inches ± 0.030	2.160 2.100	2.125	
10	Antenna Bracket	1.400Inches ± 0.030	1.430 1.370	1.400	
11	Antenna Bracket	1.260Inches ± 0.030	1.290 1.230	1.260	
12	Antenna Bracket	1.880Inches ± 0.030	1.910 1.850	1.880	
13	Antenna Bracket	0.280Inches $+ 0.006$ $- 0.001$	0.286 0.279	0.282	Diameter
14	Antenna Bracket	0.380Inches ± 0.030	0.410 0.350	0.380	Radius
15	Antenna Bracket	0.380Inches ± 0.030	0.410 0.350	0.380	Radius
16	Antenna Bracket	0.250Inches ± 0.030	0.280 0.220	0.250	Radius
17	Antenna Bracket	0.250Inches ± 0.010 ± 0.005	0.260 0.240	0.252	
18	Antenna Bracket	2.500Inches ± 0.030	2.530 2.470	2.497	
19	Antenna Bracket	0.250Inches ± 0.010	0.260 0.240	0.250	
20	Antenna Bracket	4.250Inches ± 0.030	4.280 4.220	4.250	
21	Antenna Bracket	0.250Inches ± 0.030	0.280 0.220	0.250	Radius

DTP 19-05-06 HA

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					